



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBST2162-3
Job Sheet 194418



Part No: RBST2162-3

Job Qty: 4 pcs

Part Name: Retainer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/2/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST2100 REV 7 IPP Rev. A 19.04.04 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-2500Y - 1	4 pcs	6/20/19	6/20/19	0.00	2.00	SL-2500Y - 1		SL 19-5-10
120	QC 2	4 pcs	6/20/19	6/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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CANADA
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Container No: S180331



Part: RBST2162-3

Job No: 194418

Serial No/Batch: S180331

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 05/10/19

				QC 2 - 5		DAS 71 9-89
				QC 2 - 71		
130	Conventional Mill - 1 - B4B	4 pcs	6/20/19	0.00 0.00	Conventional Mill - 1 - B4B	
					Conventional Mill - 2 - B4B	19-5-27
140	QC 2	4 pcs	6/20/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
QC 2 - 71						
150	QC 8	4 pcs	6/20/19	0.00 0.00	QC 8 - 12	19-5-27
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
QC 8 - 40						
QC 8 - 52						
					Plex 5/2/19 8:15 AM Dart.lajeunesse.marie	

				QC 8 - 23	
180	Packaging 3-1 - Stock - B4B 4 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	Dara M
190	QC 21 - SA	6/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - MORI SL2500Y LATHE) 1-Machine as per DWG. FC 777 FOLIO REV: AA DWG REV: 0.00

Descriptions: 1 2-Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

130 - Manufacture as per dwg - Machine as per DWG

140 - QC2- Inspect parts off machine FAI/FAIB

150 - QC8- Inspect parts - second check

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R2.000	Bronze C63000 Round Bar 2.000	.1680 ft (.042 ea) 0.23	110-SL-2500Y - 1	5048984

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-2500Y - 1	MT-BRONZE-C63000-R2.000	0	1	0

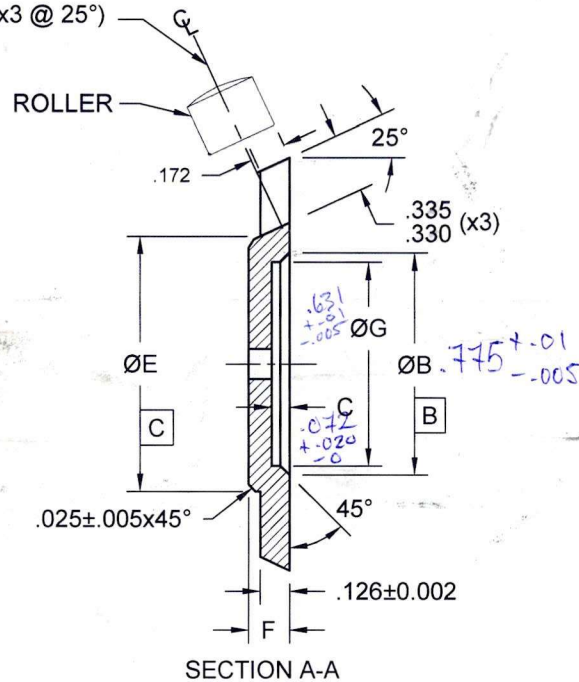
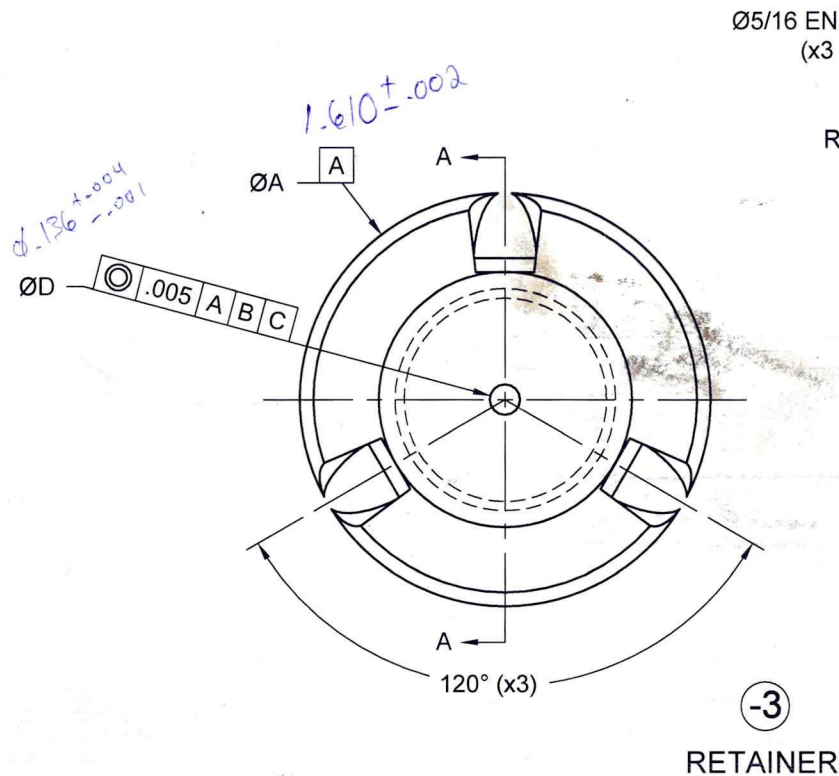
Part Specifications

Specifications could not be found.

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1599-1670
1691

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING. ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 - .000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 - .010, TO .015 - .020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194418415
19-05-02

TOOL #	ØA +.002 -.002	ØB +.010 -.005	C +.020 -.000	ØD +.004 -.001	ØE +.000 -.015	F +.010 -.010	ØG +.010 -.005	P.D. REF.	MATERIAL
RBST2120	1.540	.700	.150	.136	.644	.210	.530	.968	BRONZE RND. BAR Ø1-5/8 x 3/8
RBST2128	1.857	1.077	.070	.136	0	0	.937	1.283	BRONZE RND. BAR Ø1-7/8 x 1/4
RBST2162	1.610	.775	.072	.136	0	0	.631	1.025	BRONZE RND. BAR Ø1-5/8 x 1/4

- NOTES
1. BREAK ALL SHARP CORNERS
(.015/.03).

RB RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; RETAINER	
DWG NO. TOOL# (see chart)-3	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
SHEET 3 of 9	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

